

NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA IS NOT REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

NASA		FED SUP CLASS 4730
SCHEDULE:	ADD "A" AFTER DASH NUMBER TO DENOTE .035" TUBE WALL. ADD "B" AFTER DASH NUMBER TO DENOTE .049" TUBE WALL. ADD "C" AFTER DASH NUMBER TO DENOTE .058" TUBE WALL. ADD "D" AFTER DASH NUMBER TO DENOTE .065" TUBE WALL. ADD "E" AFTER DASH NUMBER TO DENOTE .072" TUBE WALL. ADD "F" AFTER DASH NUMBER TO DENOTE .095" TUBE WALL. ADD "G" AFTER DASH NUMBER TO DENOTE .109" TUBE WALL. ADD "H" AFTER DASH NUMBER TO DENOTE .120" TUBE WALL. ADD "J" AFTER DASH NUMBER TO DENOTE .134" TUBE WALL. ADD "K" AFTER DASH NUMBER TO DENOTE .156" TUBE WALL. ADD "L" AFTER DASH NUMBER TO DENOTE .188" TUBE WALL.	
MATERIAL:	SEE PROCUREMENT SPECIFICATION. CORROSION RESISTANT STEEL (CLASS 316), CODE "K"	
FINISH:	SURFACE SHALL BE 125 RMS MAXIMUM PER ANSI B46.1 UNLESS OTHERWISE SPECIFIED.	
NOTES:	1. REMOVE BURRS AND SLIVERS. BREAK SHARP EDGES UNLESS OTHERWISE NOTED. 2. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE DECIMALS ±.016. 3. FOR DESIGN FEATURE PURPOSES, THIS DRAWING TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. 4. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON THE DATE OF INVITATION FOR BID. 5. MARKING OF FITTINGS SHALL BE CONSISTANT WITH PROCUREMENT SPECIFICATION USING APPLICABLE KC STANDARD AND PART NUMBER DESIGNATIONS AS SHOWN ON THIS DRAWING. 6. DIAMETER "P" APPLICABLE TO KC145K208 AND KC145K248 ONLY. 7. ALL DIAMETRAL DIMENSIONS SHALL BE CONCENTRIC WITH "C" BORE WITHIN .005 T.I.R. 8. FITTINGS PROVIDED HEREIN SHALL BE WELDED TO CORRESPONDING TUBE SIZES USING AUTOMATIC WELDING EQUIPMENT (ASTRO-ARC CO. OR EQUIVALENT).	
EXAMPLE OF PART NOS.	KC145K4A= SPUD, BUTTWELD TUBE, FOR 1/4" X .035 WALL TUBING.	
CUSTODIAN: JOHN F. KENNEDY SPACE CENTER		
PROCUREMENT SPEC. KSC-F-124	SPUD, BUTTWELD TUBE	STANDARD PART
COORDINATION STATUS		KC145
KSC DE		SHEET 1 OF 2

KSC FORM 32-85 (CG 4/92)

FED SUP CLASS
4730

DASH NO.	TUBE SIZE REF	A ±.003	B +.005 -.000	C ±.003	D +.005 -.000	E ±.003	F ±.005	G ±.005	H (REF)	J ±.005	K ±.005	L ±.005	M (REF)	N ±.005	P +.000 -.003
K4A	¼" X .035	.285	.255	.172	.258	.297	.299	.315	.383	.385	.328	.165	.878	.350	-
K6A	⅜" X .035	.410	.380	.297	.383	.428	.434	.441	.502	.385	.395	.245	1.025	.350	-
K6C	⅜" X .050	.410	.380	.251	.383	.428	.434	.441	.502	.385	.395	.245	1.025	.350	-
K8B	½" X .049	.546	.506	.393	.509	.554	.564	.589	.682	.385	.405	.280	1.070	.350	-
K8E	½" X .072	.546	.506	.347	.509	.554	.564	.589	.682	.385	.405	.280	1.070	.350	-
K12D	¾" X .065	.816	.756	.611	.759	.804	.828	.880	.972	.535	.405	.300	1.240	.500	-
K12G	¾" X .109	.816	.756	.523	.759	.804	.828	.880	.972	.535	.405	.300	1.240	.500	-
K16F	1" X .095	1.066	1.006	.801	1.009	1.054	1.083	1.130	1.222	.535	.405	.400	1.340	.500	-
K16H	1" X .120	1.066	1.006	.751	1.009	1.054	1.083	1.130	1.222	.535	.405	.400	1.340	.500	-
K20B	1¼" X .049	1.330	1.256	1.143	1.259	1.304	1.341	1.412	1.536	.535	.475	.400	1.410	.500	1.134
K20J	1¼" X .134	1.330	1.256	.973	1.259	1.304	1.341	1.412	1.536	.535	.475	.400	1.410	.500	-
K24B	1½" X .049	1.605	1.511	1.398	1.514	1.559	1.611	1.630	1.786	.535	.485	.475	1.495	.500	1.370
K24J	1½" X .134	1.605	1.511	1.218	1.514	1.559	1.611	1.630	1.786	.535	.485	.475	1.495	.500	-
K24K	1½" X .156	1.605	1.511	1.174	1.514	1.559	1.611	1.630	1.786	.535	.485	.475	1.495	.500	-
K24L	1½" X .188	1.605	1.511	1.120	1.514	1.559	1.611	1.630	1.786	.535	.485	.475	1.495	.500	-
K32D	2" X .065	2.105	2.011	1.866	2.014	2.059	2.161	2.195	2.411	.535	.635	.540	1.710	.500	-
K32L	2" X .188	2.105	2.011	1.620	2.014	2.059	2.161	2.195	2.411	.535	.635	.540	1.710	.500	-

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CUSTODIAN:

JOHN F. KENNEDY SPACE CENTER

PROCUREMENT SPEC.
KSC-F-124

COORDINATION STATUS

KSC DE

SPUD, BUTTWELD TUBE

STANDARD PART

KC145

SHEET 2 OF 2

REVISED: ○

APPROVED: 5-1-90

KSC FORM 32-85 (CG 4/92)